

Work Order ID 53458

Page 1

November 6, 2009 8:21:19 AM

Item ID: D3175-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Mounting Lug

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 09/11/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3175	Rev A

100



BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

(2) blanks required per (1) D3175-041 assembly Cut blanks: 2.5" x 1.5" x 2.2"
(grain along 2.2")

JL 09/11/16

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA293 and Dwg D3175 Deburr and Tumble Identify as
D3175-112nd 0JL / mrs
09/11/17

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

JL / mrs
09/11/1712nd 0

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Quality Control

anf 09/11/17

12 10

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> M 09/10/18



HandFinish

Hand Finishing

0.00

(24) 08

150

QC3- Inspect Part Finish

0.00

BK 09-11-18



QC

Quality Control

(24) _____

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Small Fab

0.00

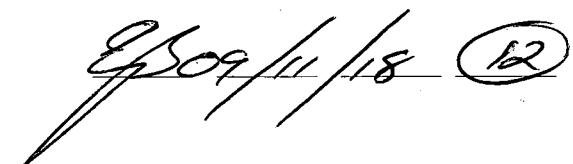
Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3175



170



QC5- Inspect part completeness to step on W/O

0.00

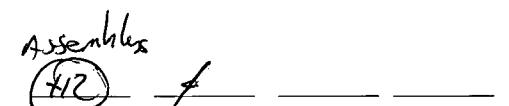


QC

Memo

0.00

Quality Control

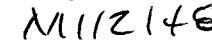


180



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

 START TIME: 11:00AM OVEN TEMPERATURE: 320°
 FINISH TIME: 11:30AM



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Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

WMO 09/11/18



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 72

0.00



Packaging

Memo

0.00

Packaging

Pc 9/11/20 72

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/2018

PL 09-11-20
12

Picklist Print

Page 1
13

November 6, 2009 8:21:23 AM

Work Order ID: 53458



Parent Item: D3175-041RevA



Parent Item Name: Mounting Lug

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 		Purchased		No		100	Each	3,196.000	24.0000		 09/11/18	

Nut

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	3196	
110844	32	
111274	27	
111668	645	24
112314	1992	
112385	500	

AN3-7A



Purchased

No

160

Each

57.0000 24.0000



Bolt

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	57	
110704	2	
111127	55	24

Picklist Print

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November 6, 2009 8:21:23 AM

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Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L 		Purchased		No		160	Each	5,721.000	48.0000		<i>EF09/11/18</i>	

Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	5721	
101291	16	
104885	153	
105793	236	
109632	412	
110985	4904	

D3175-3RevA

Manufactured

No

160 Each 15.0000 12.0000



Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	15	
25027	15	

Picklist Print

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Parent Item Name: Mounting Lug

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased		No		160	f	104.5115	2.4202			

6061-T6 Bar 1.50 x 2.50



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	104.5115	
103069	12	
107387	70	
16716	20.7115	2.4202
16742	1.8	

and 09/11/17

D3065-5DART AEROSPACE LTD	Work Order:	53415V
Description: Bracket	Part Number:	D3175-1
Inspection Dwg: D3175	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

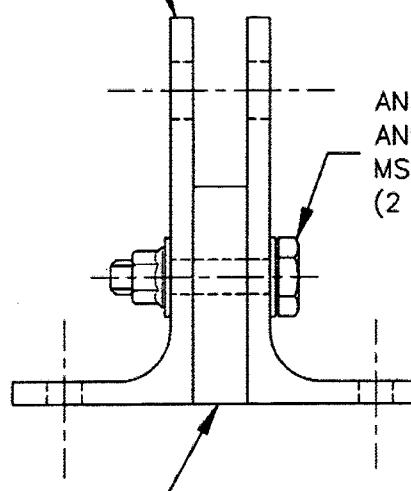
Measured by:	SL	Audited by:	CMF	Prototype Approval:	N/A
Date:	09/11/16	Date:	09/11/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3175-041	KJ/RF	TT

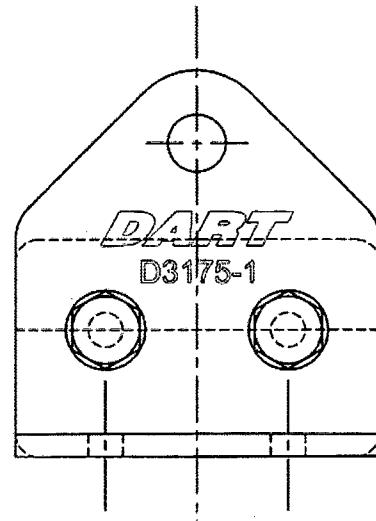


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3175 REV. A SHEET 1 OF 2
DATE		SCALE 1:1
02.12.03		MOUNTING LUG
A	02.12.03	NEW ISSUE

D3175-1
(2 PLACES)



AN3-7A BOLT (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)



D3175-3

D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3

RELEASED
02.12.03 #

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

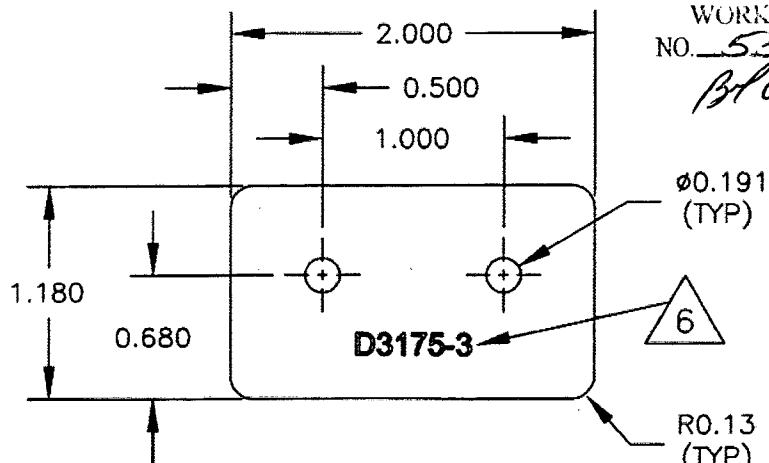
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 53-158

B109-11-5



D3175-3 SPACER

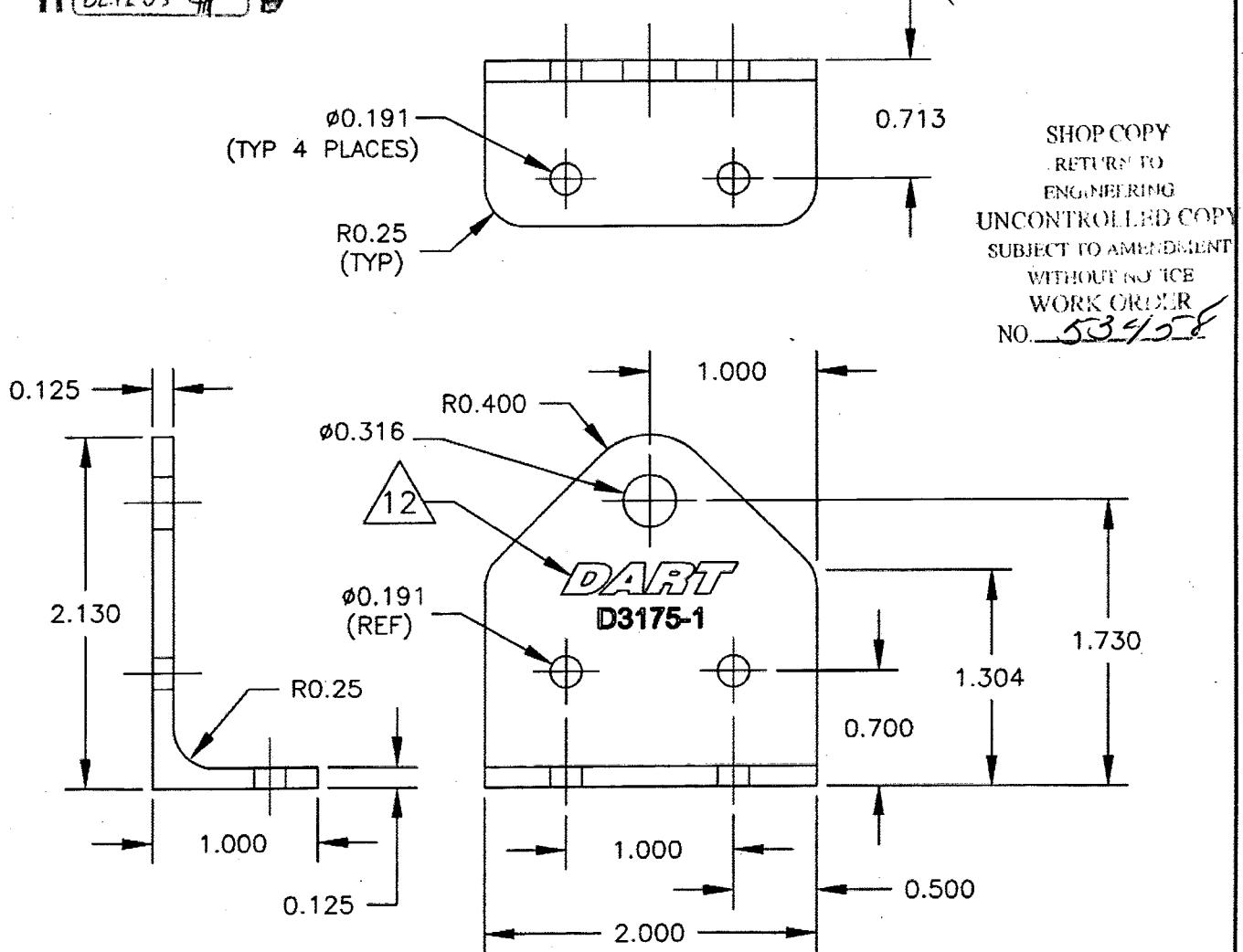
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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03175

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3175	SHEET 2 OF 2
DATE		TITLE	SCALE
02.12.03		MOUNTING LUG	1:1

RELEASED
02.12.03**D3175-1 BRACKET**

- 7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE IN INCHES

12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX